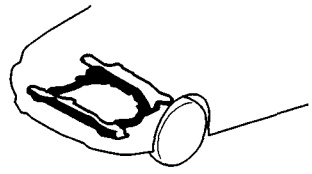
Replacement

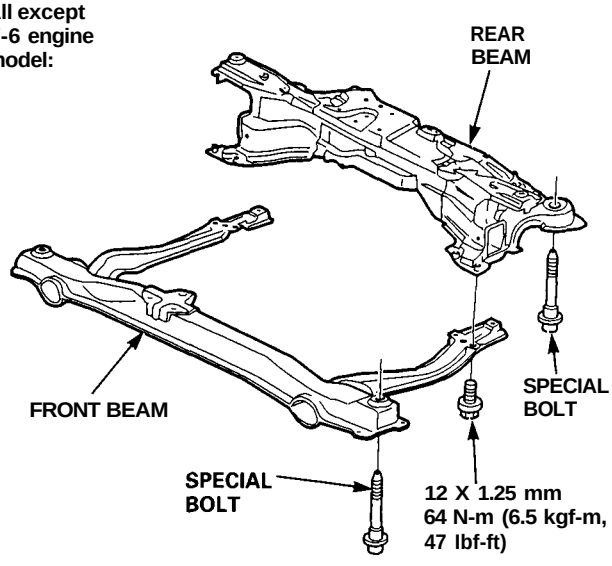
1. Remove the related parts.
   - Front suspension parts
   - Brake house and lines
   - Engine compartment electrical components
   - Fittings in passenger compartment, etc.
   - Steering gearbox.

2. Remove the front sub-frame.

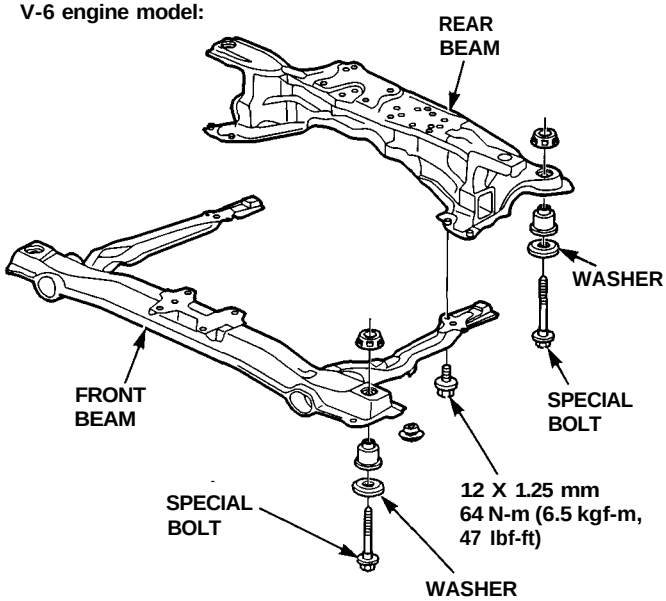
SPECIAL BOLT:
14 X 1.5 mm
103 N-m (105 kgf-m, 76 lbf-ft)
Replace.



All except V-6 engine model:



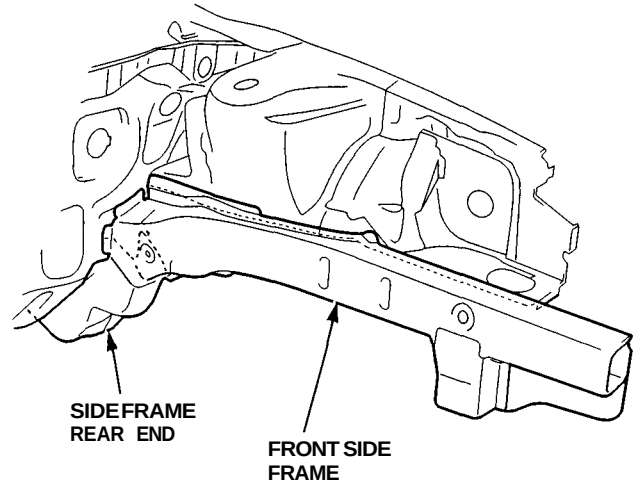
V-6 engine model:



3. Roughly pull out and straighten the damaged area.
   - Attach the vehicle to the frame straightener by tightening the underbody clamps located at the horizontal pinch welds.

   NOTE: Refer to the Accord Service Manual for safety stand location points.

   - Before cutting off the damaged sections, pull them out so that they are restored to the original shape.
   - Cutting off the front side frame before pulling out the damage makes repair of the front floor, lower dashboard, and other related parts difficult.



4. Peel off the undercoat. Heat the undercoat at the weld areas of the lower dashboard, front floor and side sill with a gas torch and peel off the undercoat with a metal spatula.

   CAUTION: Be careful not to burn the fittings inside the passenger compartment and dashboard insulator when heating.

5. Remove the front side frame.

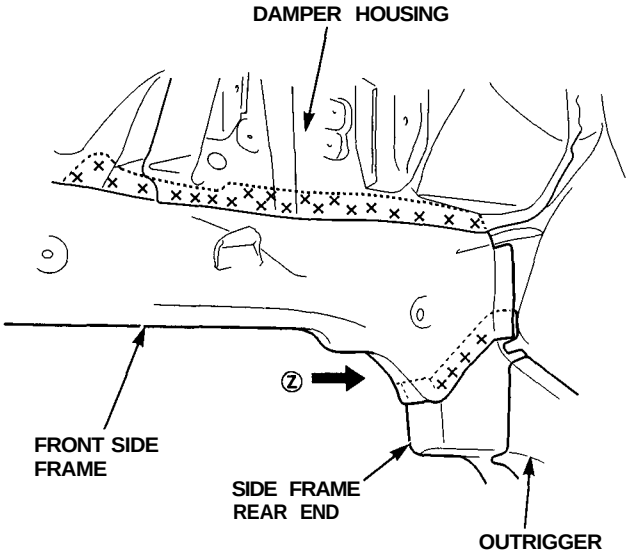
   NOTE: It's not necessary to separate the front wheelhouse from the front side frame if the wheelhouse/damper housing need replacing also.

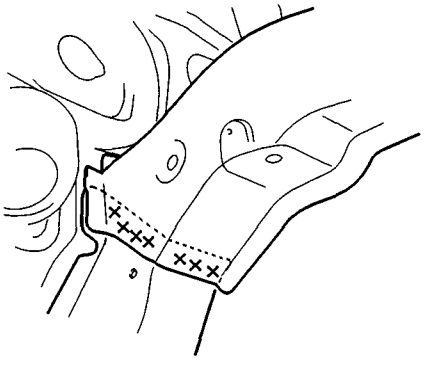
   - Center punch around the spot weld imprints on the wheelhouse, damper housing, lower dashboard, and side frame rear end.
   - Using a spot cutter, drill holes in the spot welded areas.
   - Peel off the welding flange using a chisel.

(cont'd)

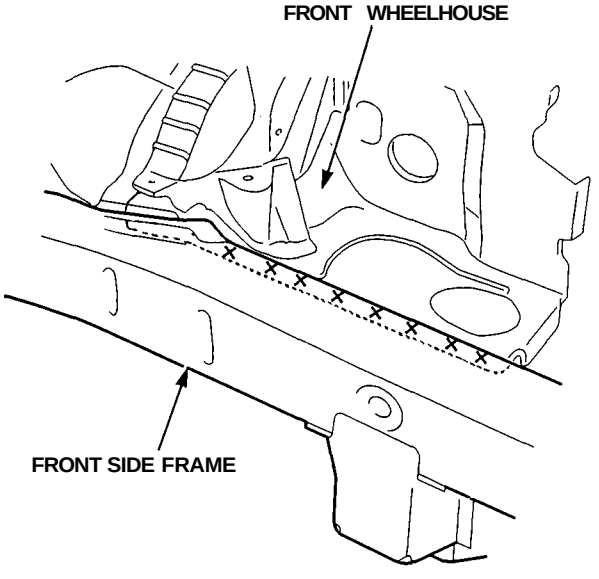
Front Side Frame/Side Frame Rear End

Replacement (cont'd)



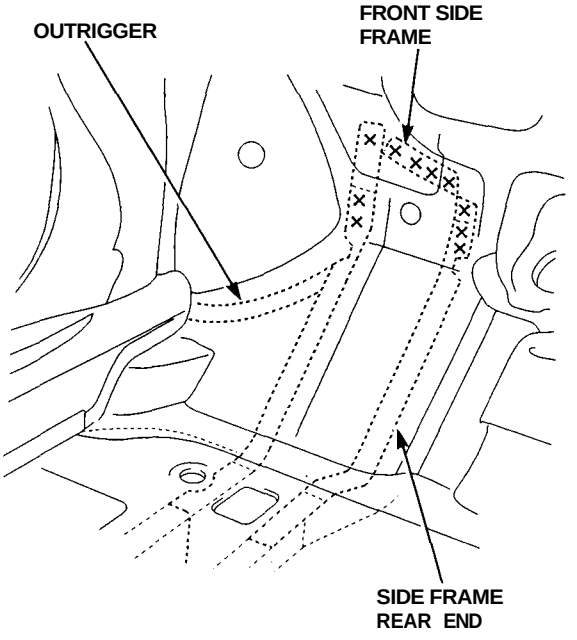


VIEW Ⓩ

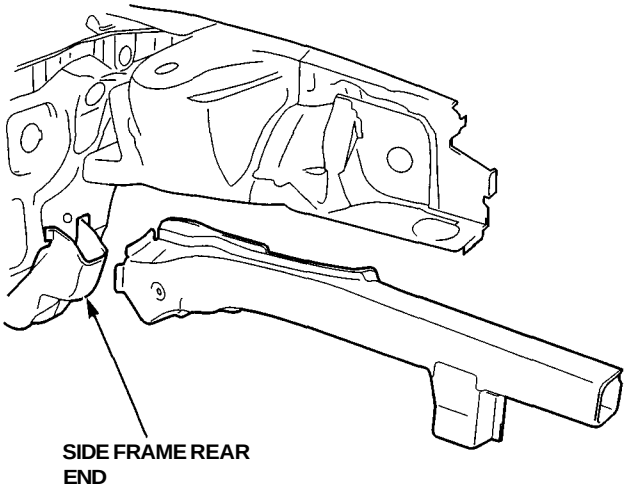


- Center punch around the spot weld imprints on the front side frame from inside the passenger compartment.
- Drill holes in the spot welded area with a 5 mm (0.2 in) drill.

NOTE: Drill holes completely through the parts since the replacement front side frame will be welded by MIG welding.

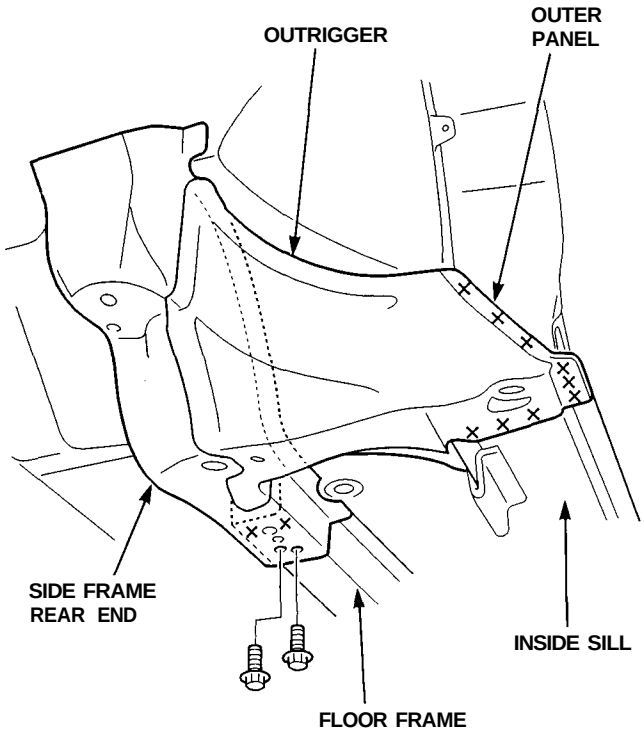


6. Check the side frame rear end and outrigger for position and damage.
   If necessary, replace the side frame rear end and outrigger as an assembly.



- Center punch around the spot weld imprints on the outer panel, floor frame, and inside sill.
- Drill holes in the center punched areas using a spot weld cutter.

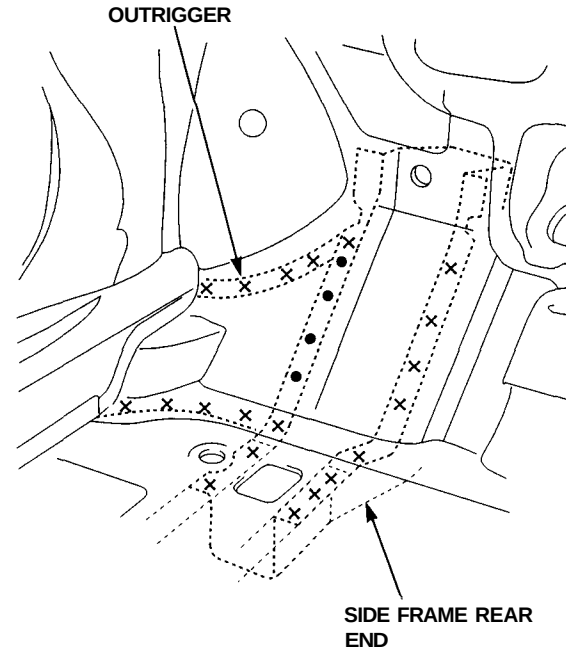
NOTE: When drilling holes be careful not to drill down to the floor frame and the inside sill.



- Center punch around the spot weld imprints on the side frame rear end and outrigger from inside the passenger compartment.
- Drill holes is the spot welded areas with a 5 mm (0.2 in) spot weld cutter.

NOTE: Drill holes through the parts completely since the replacement side frame rear end and outrigger will be welded b MIG welding.

- Remove the MIG welds of the side frame rear end and lower dashboard with a disc sander.



- Level off and finish the burrs of the pried off spot welds with a disc sander.

⚠ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

7. Straighten the related parts.
   Reshape the lower dashboard, floor frame, front floor, inside sill and side sill inner joint using a hammer and dolly. Check the floor frame and inside sill for position and damage.

8. Set the new front side frame.
   - Remove the undercoat from the both sides of the welding section, and expose the steel plate using a disc sander.

⚠ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

NOTE: Apply the spot sealer to the welding surface when spot welding.

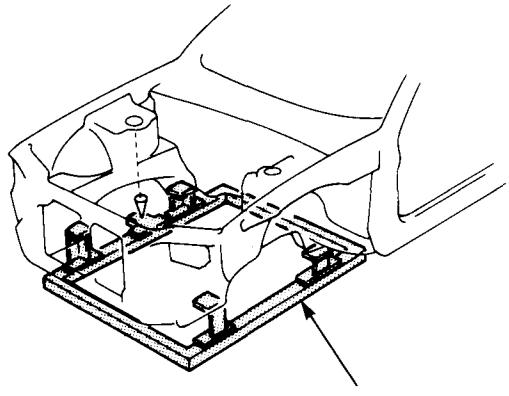
(cont'd)

Front Side Frame/Side Frame Rear End

Replacement (cont'd)

- Tighten the front side frame against the front floor and side sill using vise-grips or pliers.
- Drill 3 mm (0.12 in) holes, and screw 5 mm self-tapping screws into the drilled holes at the areas where the side frame rear end and outrigger does not fit closely.
- Even out the welded flange and damaged area with a hammer and dolly.
- Place a jack under the side frame rear end and support it, then measure the positions for temporary attachment.

NOTE: Use of a positioning jig is recommended (see page 1-8).



POSITIONING JIG

- Clamp the front bulkhead and front wheelhouse/ damper housing with squill vises and vise-grips.
- Measure the front compartment diagonally.
- Spot weld several points in the clamped sections, and temporarily attach the front side frame and side frame rear end.

⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Check the body dimensions (see section 6).
- Install the new sub-frame, and check the front side frame position.

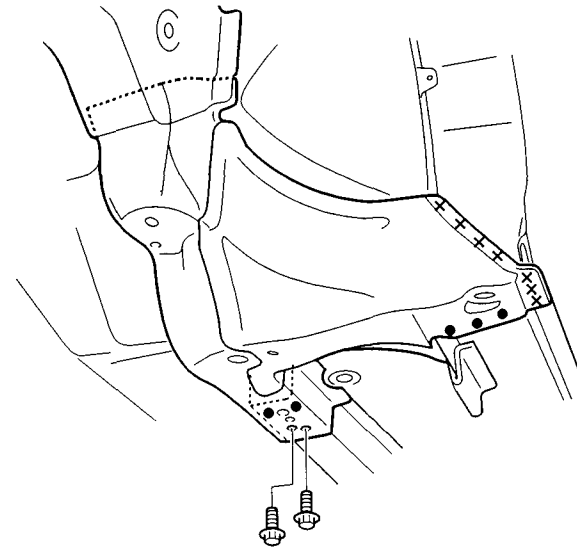
9. Perform the main welding.
   - Make 20% to 30% more spot welds than there were holes drilled.

NOTE: If additional spot welding is not possible compensate by using the MIG weld.

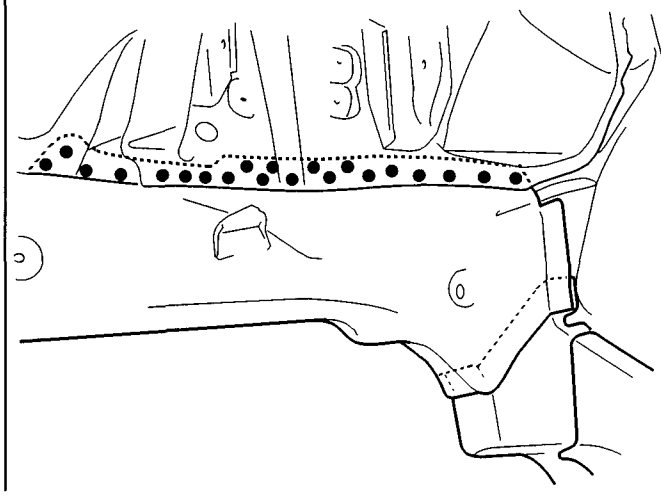
- Weld as much as possible with the jig still mounted.

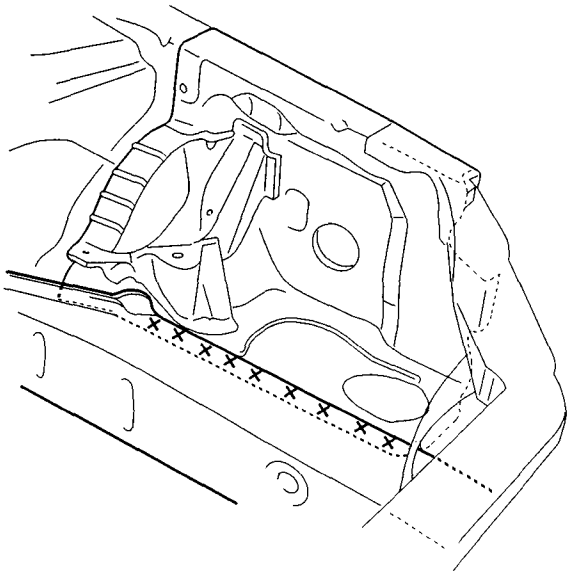
⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves, and safety shoes.

- MIG weld the side frame rear end, outrigger and floor frame.

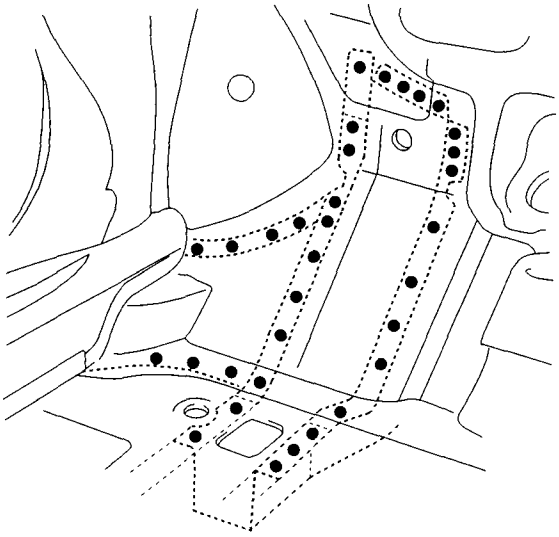


- Weld the front side frame, wheelhouse, damper housing, and bulkhead.





- From the passenger compartment side, plug weld the holed areas of the lower dashboard and front floor with a MIG welder.



10. Finish the welds. Use a hammer and dolly to even out the damper housing, wheelhouse, lower dashboard, front bulkhead and side sill flanges for a close fit with the surface of the front side frame.

11. Apply sealer (see section 5) to the mating surfaces of the lower dashboard, etc.

12. Apply the paint. See Paint Repair section.

⚠ WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

13. Apply the undercoat.
    Undercoat the front floor, and apply anti-rust agent to the inside of the welding section of the side sill, front side frame, side frame rear end and outrigger (see section 7).

14. Install the related parts in the reverse order in which they were removed.

15. Inspect, check, and adjust.
    - Measure the front wheel alignment.
    - Inspect the brake system.
    - Adjust the headlight aim.